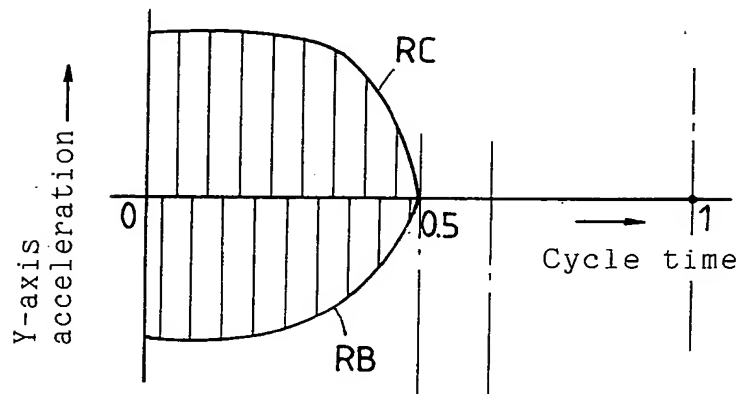


FIG. 1

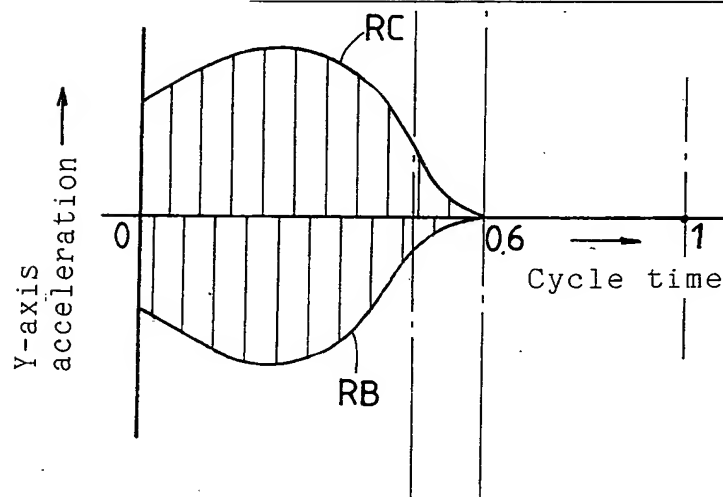
Rotating velocity of  
work spindle rises on optimal curve

(A)



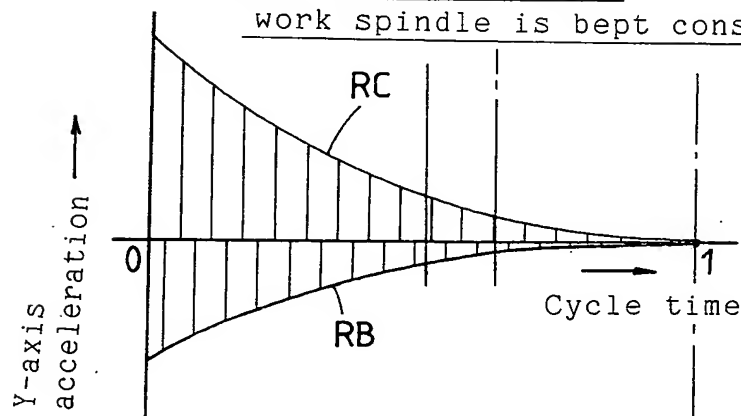
Rotating velocity of  
work spindle rises linearly

(B)



Rotating velocity of  
work spindle is kept constant

(C)



**FIG. 2**

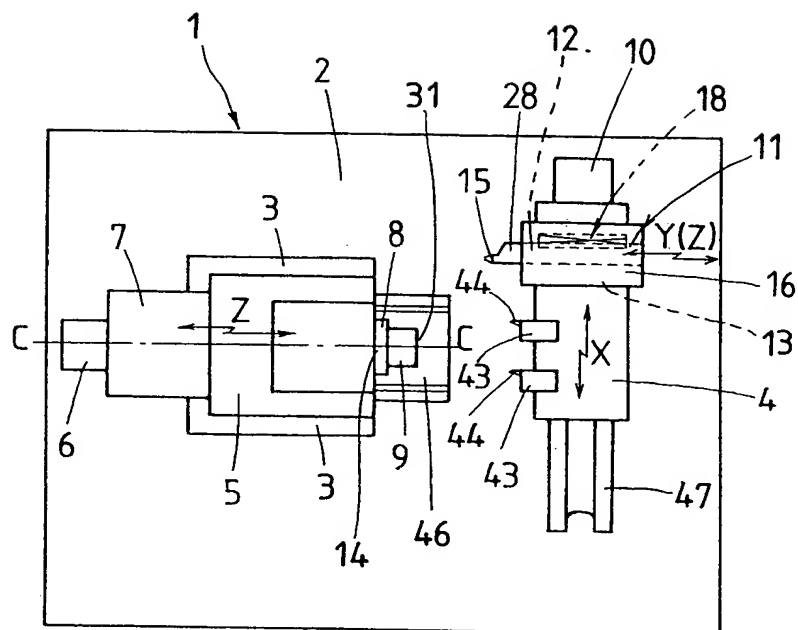


FIG. 3

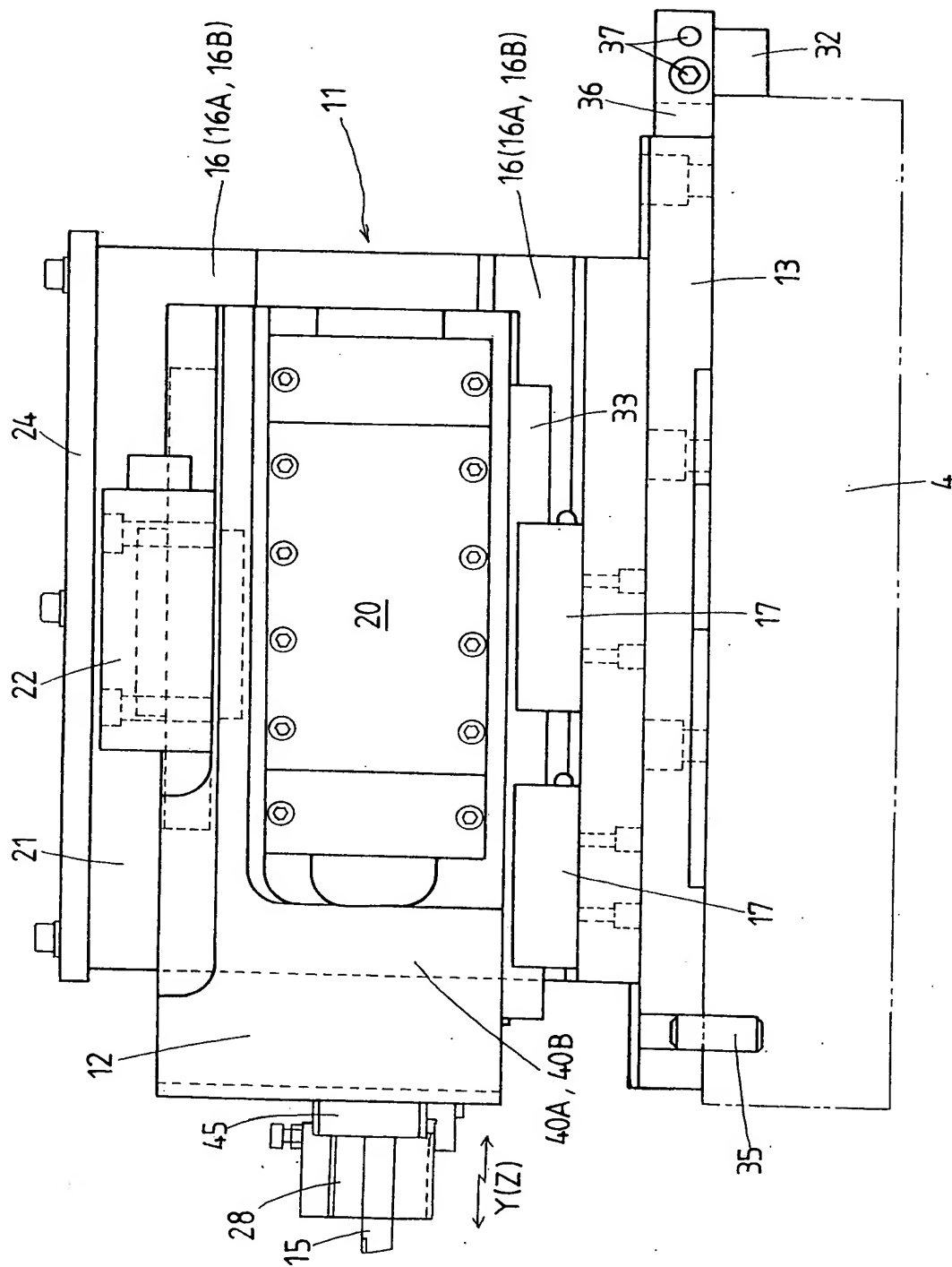
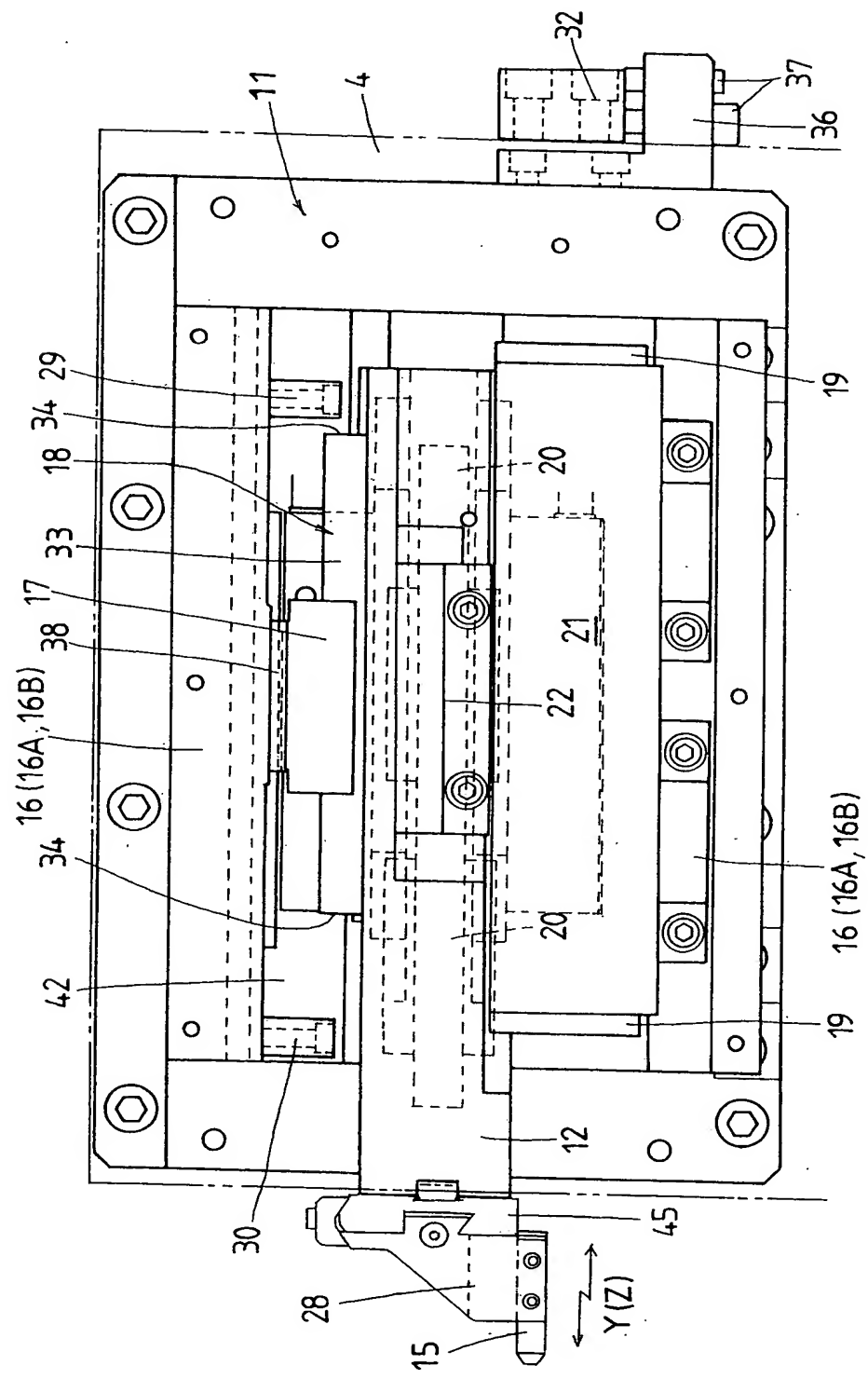
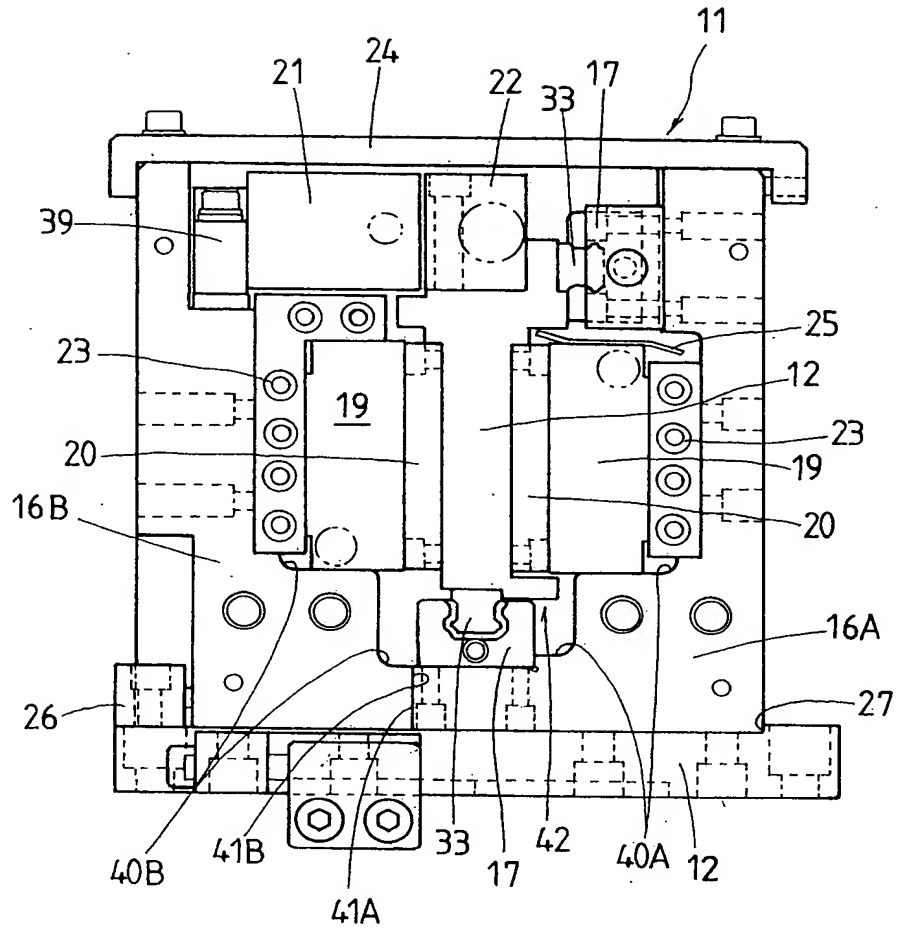


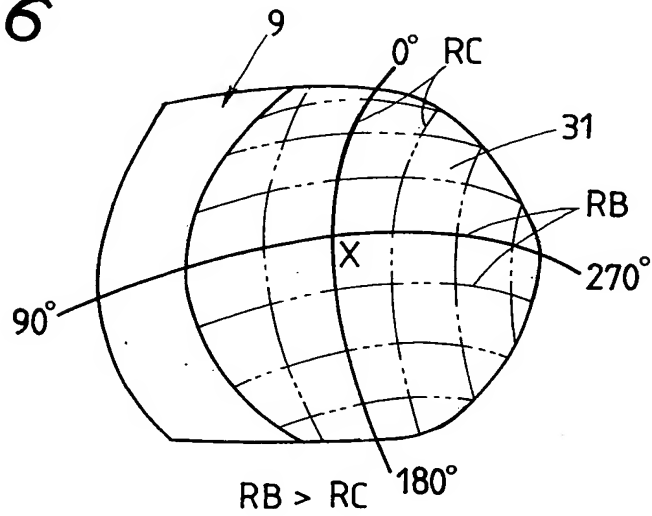
FIG. 4



**FIG. 5**



**FIG. 6**



# FIG. 7

